

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017930**Date Inspected:** 01-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates located outside PCMK OBG 11DE/11EE, across the transverse joint, side plate, south (bikepath) side. Welder was identified as 040484. QC was identified as ZPMC QC Shi Lei (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Wang Li Yang (QCA1), who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

SMAW welding of temporary alignment plates located outside PCMK OBG 11DE/11EE, across the transverse joint, side plate, north (crossbeam) side. Welder was identified as 056364. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding variables recorded by QCA1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA1.

SMAW welding of temporary alignment plates located inside PCMK OBG 11DE/11EE, across the transverse joint, deck plate. Welders were identified as 050038, 056200. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was QCA1, who was not a CWI. Welding

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variables recorded by QCA1 appeared to comply with WPS-B-P-2112-FCM-1 as verbally identified by QCA1.

SMAW welding of temporary alignment plates located outside PCMK OBG 11DW/11EW, across the transverse joint, side plate, south (crossbeam) side. Welder was identified as 041713. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QC1.

SMAW welding of temporary alignment plates located outside PCMK OBG 11DW/11EW, across the transverse joint, side plate, north (counterweight) side. Welder was identified as 044551. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QC1.

SMAW welding of temporary alignment plates located outside PCMK OBG 11DW/11EW, across the transverse joint, edge plate, south (crossbeam) side. Welder was identified as 218711. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2112-FCM-1 and WPS-B-P-2114-FCM-1 as verbally identified by QC1.

SMAW welding of temporary alignment plates located inside PCMK OBG 11DW/11EW, across the transverse joint, deck plate. Welders were identified as 062935, 057333. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QC1.

FCAW welding of temporary alignment plates located outside PCMK OBG 11DW/11EW, across the transverse joint, deck plate. Welders were identified as 049220. QC was identified as QC1. Welding variables recorded by QC1 appeared to comply with WPS-B-T-2132 as verbally identified by QC1.

Heavy Dock

This QA Inspector randomly observed the following on the Heavy Dock:

All 4 towers, lift 4 were positioned on a base separate pedestal at end of the Heavy Dock. OBG segment 10E was positioned on the ship moored to the end of the Heavy Dock. West tower, lift 3 was positioned horizontally on stanchions on the deck of the Heavy Dock. ZPMC personnel were loading splice plates into west tower, lift 3, at skin A. See photos below. No welding related work was being performed on any of the tower or OBG components. The ZPMC 1600 ton floating crane was moored outboard of the ship and sitting idle.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng, 159-2184-5703, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
